

Date: Wednesday, 6/6/2007 2:01:52 PM  
User: Kim Johnston

## Process Sheet

Split  
WLO 8/07/08/27 26

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : PEDAL ASSEMBLY  
Job Number : 32814  
Estimate Number : 11005  
P.O. Number : N/A Part Number : D412704041  
This Issue : 6/6/2007 S.O. No. : N/A Drawing Number : D412-704-041 REV A  
Pst Rev. : NC Project Number : N/A  
First Issue : N/A Type : SMALL /MED FAB Drawing Revision : A  
Previous Run : 29896 Material : N/A Due Date : 6/26/2007 Qty: 1 / Um: Each  
Written By :  
Checked & Approved By :  
Comment : Est Rev:B 05.01.28 Removed hardware on Step 2; Added  
Figures 1-3 KJ/RF  
Est Rev:C 06.03.08 Re-format EC  
Est Rev:D 07-03-20 Added Dwg D412-704-041 07-03-20  
JLM  
Est Rev:E 07.05.02 Reformat EC

PTO

Additional Product

Job Number



Seq. #

Machine Or Operation:

Description :

10

D3204041

Pedal Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part number	Description	batch
1	D3204-041	Pedal Assembly	B 30829 x 5

20

D32051

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part number	Description	batch
1	D3205-1	Bracket	B 30830 x 4 B 30894 x 2

30

D32053

Back Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part number	Description	batch
1	D3205-3	GHW Bracket	B 28742 x 1

40

D32061

Pedal Arm



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part number	Description	batch
1	D3206-1	Pedal Arm	B 29915 x 6

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/03/27	18	split u/o	SS	07/03/27	(1)		

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PEDAL ASSEMBLY

Job Number: 32814

Part Number: D412704041

Job Number:



Seq. #:

Machine Or Operation:

Description:

1 D3206-1 Pedal arm

E O

D3209041

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick:

Qty	Part number	Description
1	D3209-041	Bracket

batch

B 23194 x 2

B 30832 x 4

✓  
ml

E O

AN310A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick:

Qty	Part number	Description
1	AN3-10A	Bolt

batch

M17566

✓  
ml

E O

AN3154R

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick:

Qty	Part number	Description
1	AN315-4R	Nut

batch

M17566

✓  
ml

E O

AN410A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick:

Qty	Part number	Description
1	AN4-10A	Bolt

batch

M101291

✓  
ml

E O

AN412A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty	Part number	Description
2	AN4-12A	Bolt

batch

M104547

✓  
ml 6/7/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



100  
500

Wednesday, 6/6/2007 2:01:53 PM  
Kin Johnston

# Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PEDAL ASSEMBLY

Job Number: 32814

Part Number: D412704041

Job Number:



Seq. #: Machine Or Operation: Description:

100

AN413A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick:

Qty	Part number	Description	batch
1	AN4-13A	Bolt	M104746

✓  
ml

110

AN960JD10

Washer



Comment: Qty.: 5.0000 Each(s)/Unit Total: 30.0000 Each(s)

Pick:

Qty	Part number	Description	batch
5	AN960JD10	Washer	M104885

✓  
ml

120

AN960JD416

Washer



Comment: Qty.: 11.0000 Each(s)/Unit Total: 66.0000 Each(s)

Pick:

Qty	Part number	Description	batch
11	AN960JD416	Washer	M104215

✓  
ml

130

AN960JD416L

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total: 18.0000 Each(s)

Pick:

Qty	Part number	Description	batch
3	AN960JD416L	Washer	M104214

✓  
ml

140

MS21042L3

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick:

Qty	Part number	Description	batch
1	MS21042L3	Nut	M103830

✓  
ml

150

MS21042L4

Nut



Comment: Qty.: 5.0000 Each(s)/Unit Total: 30.0000 Each(s)

Pick:

Qty	Part number	Description	batch
5	MS21042L4	Nut	M102552

✓  
ml 07/07/20

# Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PEDAL ASSEMBLY

Job Number: 32814

Part Number: D412704041

Job Number:



Seq. #:

Machine Or Operation:

Description:

1E10

MS24694S102

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick:

Qty	Part number	Description	batch
1	MS24694S102	Screw	M14604

✓  
ml

1E2

MS951910

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick:

Qty	Part number	Description	batch
1	MS9519-10	Bolt	M100290

✓  
ml 07/07/20

1E3

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble pedal as per Dwg D412-704-041

Tighten & Torque Bolts as per Dwg D412-704-041

ml 07/08/27 x1

1E4

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/08/27 TL

2E0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3E0

AN960JD10L

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 24.0000 Each(s)

Pick:

Qty	Part number	Description	batch
4	AN960JD10L	Washer	M103044

CP

04/08/27 @

cr

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## Process Sheet

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Drawing Name: PEDAL ASSEMBLY

Job Number: 32814

Part Number: D412704041

Job Number:



Seq. #:

Machine Or Operation:

Description:

22.0

AN36A

Bolt



*EP*



Comment: Qty.: 2.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty Part number Description  
2 AN3-6A Bolt

batch

*M100184 -*

23.0

MS21042L3

Nut



*EP*



Comment: Qty.: 2.0000 Each(s)/Unit Total: 12.0000 Each(s)

Nut

Batch: *M104936 -*

*EP 07/08/27@*

24.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

*EP 07/08/27*

25.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*EP 07/08/27@*

26.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

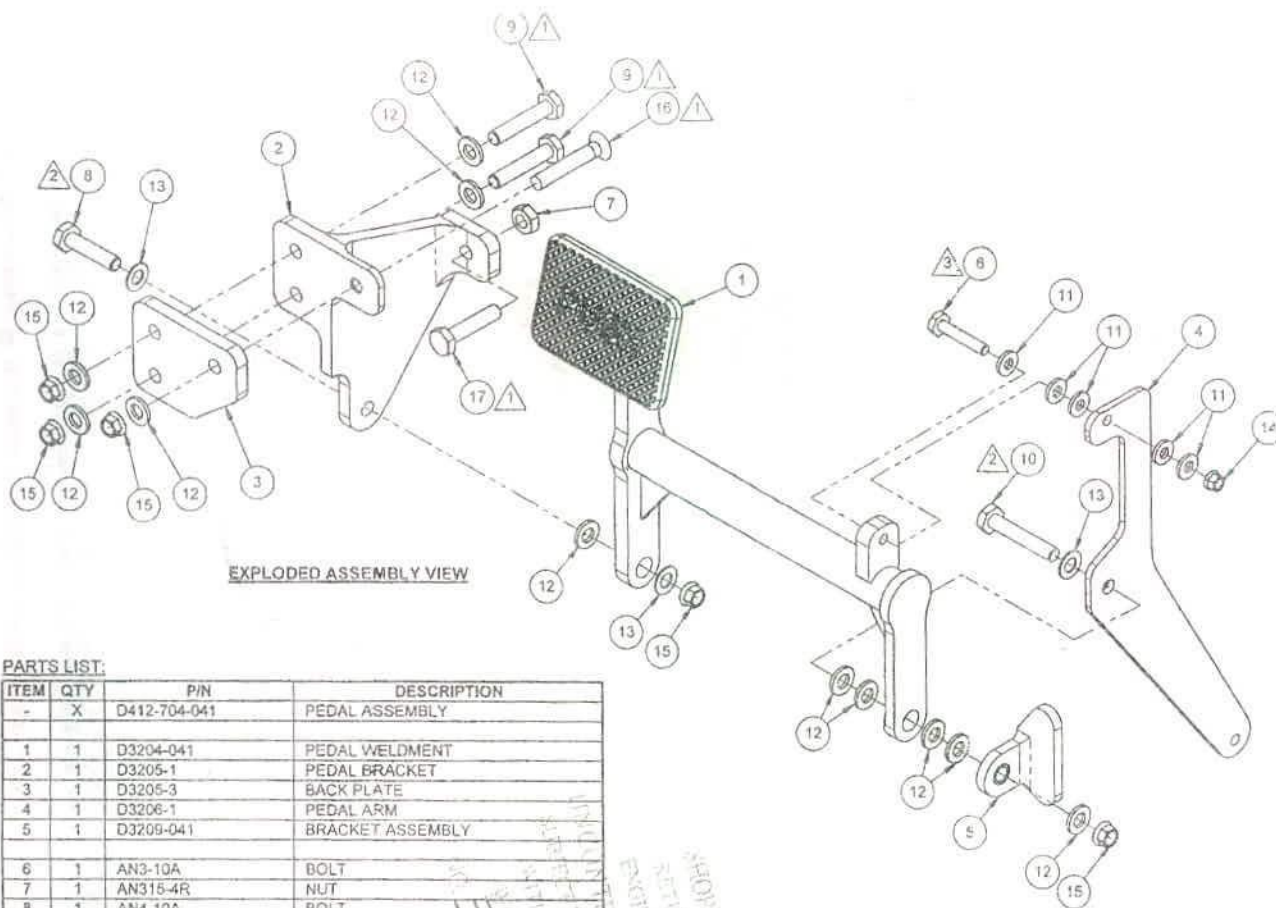
*① 07/08/08*

Completion

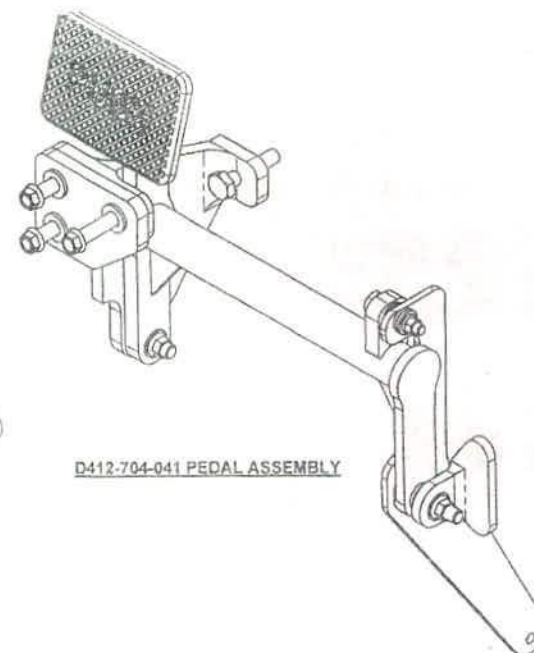


*U 07.08.28*





EXPLODED ASSEMBLY VIEW



D412-704-041 PEDAL ASSEMBLY

PARTS LIST:

ITEM	QTY	P/N	DESCRIPTION
-	X	D412-704-041	PEDAL ASSEMBLY
1	1	D3204-041	PEDAL WELDMENT
2	1	D3205-1	PEDAL BRACKET
3	1	D3205-3	BACK PLATE
4	1	D3206-1	PEDAL ARM
5	1	D3209-041	BRACKET ASSEMBLY
6	1	AN3-10A	BOLT
7	1	AN315-4R	NUT
8	1	AN4-10A	BOLT
9	2	AN4-12A	BOLT
10	1	AN4-13A	BOLT
11	5	AN960JD10	WASHER
12	11	AN960JD416	WASHER
13	3	AN960JD416L	WASHER
14	1	MS21042L3	NUT (OR MS21042-3)
15	5	MS21042L4	NUT (OR MS21042-4)
16	1	MS24694-S102	SCREW
17	1	MS9519-10	BOLT
N/A*	2	AN3-6A	BOLT
N/A*	4	AN960JD10L	WASHER
N/A*	2	MS21042L3	NUT (OR MS21042-3)

\* SHIPPED LOOSE WITH -041 KIT (NOT PRE-ASSEMBLED AT DART)

NOTES:

- 1 INSTALL IDENTIFIED FASTENERS LOOSE (HAND TIGHTEN ONLY).
- 2 TIGHTEN IDENTIFIED FASTENERS UNTIL SNUG, ENSURE THAT PARTS CAN STILL ROTATE.
- 3 TORQUE IDENTIFIED FASTENERS TO 15-25 in-lbs (1.7-2.8 N-m).

RELEASED

07.01.23

A	07.01.23	NEW ISSUE	DESCRIPTION
REV	DATE		
DESIGN	DRAWN BY		
C.B.	C.B.		
CHECKED	APPROVED		
CE	H		
DATE	07.01.23	TITLE	SCALE
		PEDAL ASSEMBLY	1:2
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